

Date: Tuesday, 28/10/2008 2:03:26 PM
User: Jean-Luc Menard

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: X-BOLT SPACER
Job Number	: 43014		
Estimate Number	: 12323		
P.O. Number	:	Part Number	: D34903
This Issue	: 28/10/2008 S.O. No. :	Drawing Number	: D3490 REV A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 42979	Material	:
Written By	: <u>28.10.28</u>	Due Date	: 04/11/2008 Qty: 100 Um: Each
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-03-03 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R0750	6061-T6 Round Bar .750"
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Comment: Qty.: 0.2793 f(s)/Unit Total: 27.9300 f(s)

6061-T6 .750" ROUND BAR

(M6061T6R0750)

Batch: M109978 or M109478 (illegible) → 7ft, M109478

08/10/29

(43)

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: HARDINGE CNC LATHE SMALL

1-TURN AS PER FOLIO FA629 & DWG D3490

FOLIO REV: ADWG REV: A

2-DEBURR AS REQUIRED

08/10/29

SA 08/10/29

(P107)

Last page

(43)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

08/10/29

SA 08/10/29

(43)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

08/10/30

(43)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: BARCLAY

08/10/30 (43)

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Process Sheet

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Drawing Name: X-BOLT SPACER

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Part Number: D34903

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/31 *[Signature]*

Comment: FINAL INSPECTION/W/O RELEASE

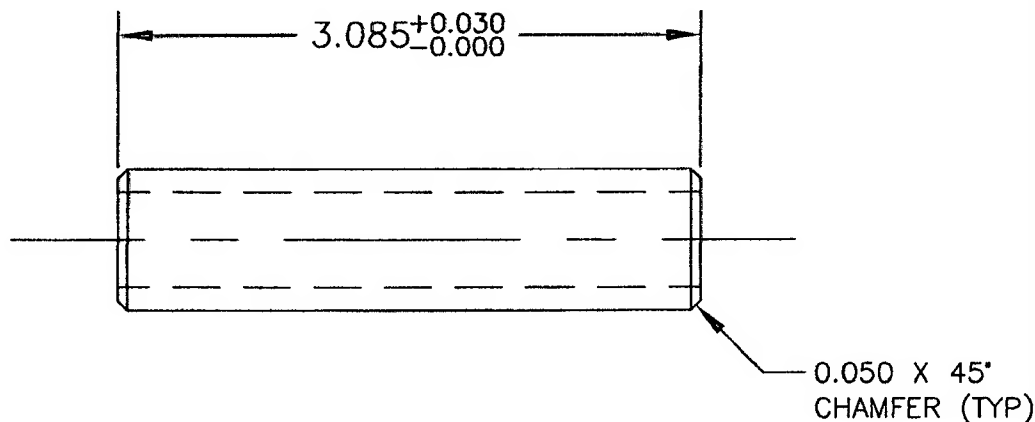
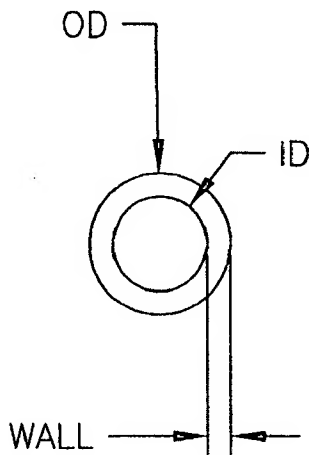
Job Completion



MF 08-10-30



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3490	REV. A SHEET 1 OF 1
DATE 06.01.04		TITLE CROSS BOLT SPACER	SCALE NTS
A	06.01.04	NEW ISSUE	



D3490-1/-3/-5 CROSS BOLT SPACER PARTS LIST

PART NUMBER	OD	WALL	ID (REF)	MATERIAL SPEC
D3490-1	0.500	0.049	0.402	M6061T6T0.500W.049
D3490-3	0.750	0.080	0.591	M6061T6R0.750
D3490-5	0.313	0.058	0.197	M6061T6T0.313W.058

D3490-1/-3/-5 CROSS BOLT SPACER

- 1) MATERIAL: ALUMINUM 6061-T6 (QQ-A-200/8 OR QQ-A-225/8)
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

w/ 43014

RELEASED
06-02-07

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3490-3 PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: D Date: 08/16/31
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: <u>43014</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/29/09	2.0 Cobra	NC of Id +.010 over tolerance due to chip build up.		at 5 08/29				
8/10/29	#20	hole size 0.591" is 0.010" over bl. RC Drill filled up with chips and was running out.	<u>JB</u> <u>08/12</u>	Scrap and Destroy and Replace Qty <u>(x13)</u> B# <u>M109978, M109478</u>	8/10/29 <u>☒</u>	<u>S</u> 08/10/30	<u>JB</u> 08/12	<u>S</u> 08/10/29

NOTE: Date & initial all entries